Qty:

1 : Um:

Each

: PB67-43001-83

: PB674300183

: 1/5/2008

Date: User:

Thursday, 12/20/2007 12:14:50 PM

Dominique Dube

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CC-DAR01 Dart Aerospace Ltd.

S.O. No. :

Type

Job Number : 36353 10804

Estimate Number

P.O. Number

: 12/20/2007 This Issue

: NC

Prsht Rev.

: // First Issue

: 36351 Previous Run

Checked & Approved By

Comment

Written By

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

: LARGE FAB ASSY

1.0



DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

ISSUE TRAVELER

2.0

WATER JET



FLOW WATER JET



Comment: FLOW WATER JET

CUT AS PER DWG B67-43001-185

2.50" X 3.0625" 0.063" THK 6061T6 B 105 235

13-12-21

CUT & DRILL HOLES AS PER DWG B67-43001-193

1.00" X 1.50" 0.125" THK 6061T6 B 105646



CUT AS PER DWG B67-43001-339

1.688" X 3.12" 0.063" THK 6061T6 B 105325



B 07-12-21

DE-BURR

M6061T6S063 3.0



6061-T6 .063 Sheet

0.05580 sf(s)/Unit

Total: 0.05580 sf(s)



M6061T6S125 4.0

Comment: Qty.:



6061-T6 .125 Sheet

Comment: Qty.:

0.01090 sf(s)/Unit

Total:

0.01090 sf(s)



P	Dart	Aero	space	Ltd
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W/O:		WORK ORDER C	HANGES		_									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
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Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	losed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	3 %	Verification	Approval Chief Eng	Annuarial			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector			

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Date: Thursday, 12/20/2007 12:14:50 PM User: **Dominique Dube Process Sheet** Drawing Name: PB67-43001-83 Customer: CC-DAR01 Dart Aerospace Ltd. Part Number: PB674300183 Job Number: 36353 Job Number: Description: Seq. #: Machine Or Operation: 5.0 M6061T6S063 0.03840 sf(s) Comment: Qty.: Total: 6061-T6 .063 Sheet INSPECT PARTS AS THEY COME OFF MACHIN 6.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 7.0 QC8 Comment: SECOND CHECK LARGE FABRICATION RESOURCE 1 LARGE FAB 1 8.0 Comment: LARGE FABRICATION RESOURCE 1 **CUT IN HALF AS PER DWG B67-43001-189** B 11306 2.50" LONG D2914-142 **DE-BURR** 9.0 D2914142 Comment: Qtv.: 1.00000 Each(s) 1.00000 Each(s)/Unit Total: 10 3" Outer Tube LAMA INSPECT WORK TO CURRENT STEP 10.0 QC5 1.3 Comment: INSPECT WORK TO CURRENT STEP 11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 WELD AS PER DWG B67-43001-83 VISUAL WELDING INSPECTION 12.0 Comment: VISUAL WELDING INSPECTION

Dart	Aeros	pace Ltd	ı
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W /O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08-01	17	Use rivet ms acualano 3-4 instead of " CCP 364553 4 B 102404 (4)	mF	08.01-	4	08.01.07	08/61/12

Part No:	PAR #:	Fault Category:	_ NCR: Yes No	DQA:	Date:
			QA: N/C	Closed:	Date:

,		WORK ORDER NON-CONFORMANCE (NCR)								
	Description of NC		Corrective Action Section B		Varification	Anneugl	Ammanal			
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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	STEP	STEP Description of NC Section A	STEP Description of NC Section A Initial Chief Eng	STEP Description of NC Section A Initial Chief Eng Chi	STEP Description of NC Section A Initial Chief Eng Chief	STEP Description of NC Section A Chief Eng Corrective Action Section B Sign & Date Section C Sec	STEP Description of NC Section A Initial Chief Eng Chief Eng Section B Section B Section C Secti			

Thursday, 12/20/2007 12:14:50 PM Date: User: **Dominique Dube Process Sheet** Drawing Name: PB67-43001-83 Customer: CC-DAR01 Dart Aerospace Ltd. Part Number: PB674300183 Job Number: 36353 Job Number: Seq. #: Description: Machine Or Operation: HAND FINISHING1 HAND FINISHING RESOURCE #1 13.0 Comment: HAND FINISHING RESOURCE #1 CHEMICAL CONVERSION COAT AS PER QSI005 4.1 (ALODINE) INSPECT POWDER COAT/CHEMICAL CONVERSION 14.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION HAND FINISHING RESOURCE #1 HAND FINISHING1 Comment: HAND FINISHING RESQURCE #1 POWDER COAT GREEN SANDTEX AS PER QSI005 4.3 (4.35.8) INSPECT POWDER COAT/CHEMICAL CONVERSION 16.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION LARGE FABRICATION RESOURCE 1 17.0 Comment: LARGE FABRICATION RESOURCE 1 B_M106576 PICK MS21075L3 NUT PLATE QTY 2 PICK CCR264SS3-4 BLIND RIVET QTY 4 B. mf 08-01-07 INSTALL NUT PLATE WITH RIVETS AS PER DWG B67-43001-83 18.0 MS21075L3 Comment: Qtv.: 2.00000 Each(s)/Unit Total: 2.00000 Each(s) **Nutplate** CCR264SS304 19.0 Comment: Qty.: 4.00000 Each(s)/Unit Total: 4.00000 Each(s) RIVET

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W/O:		WORK ORDER CH	IANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				

Part No:	_ PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:
			QA: N	I/C CI	osed:	Date:

NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)								
· · · · · · · · · · · · · · · · · · ·		Description of NC		Corrective Action Section B		Verification	A				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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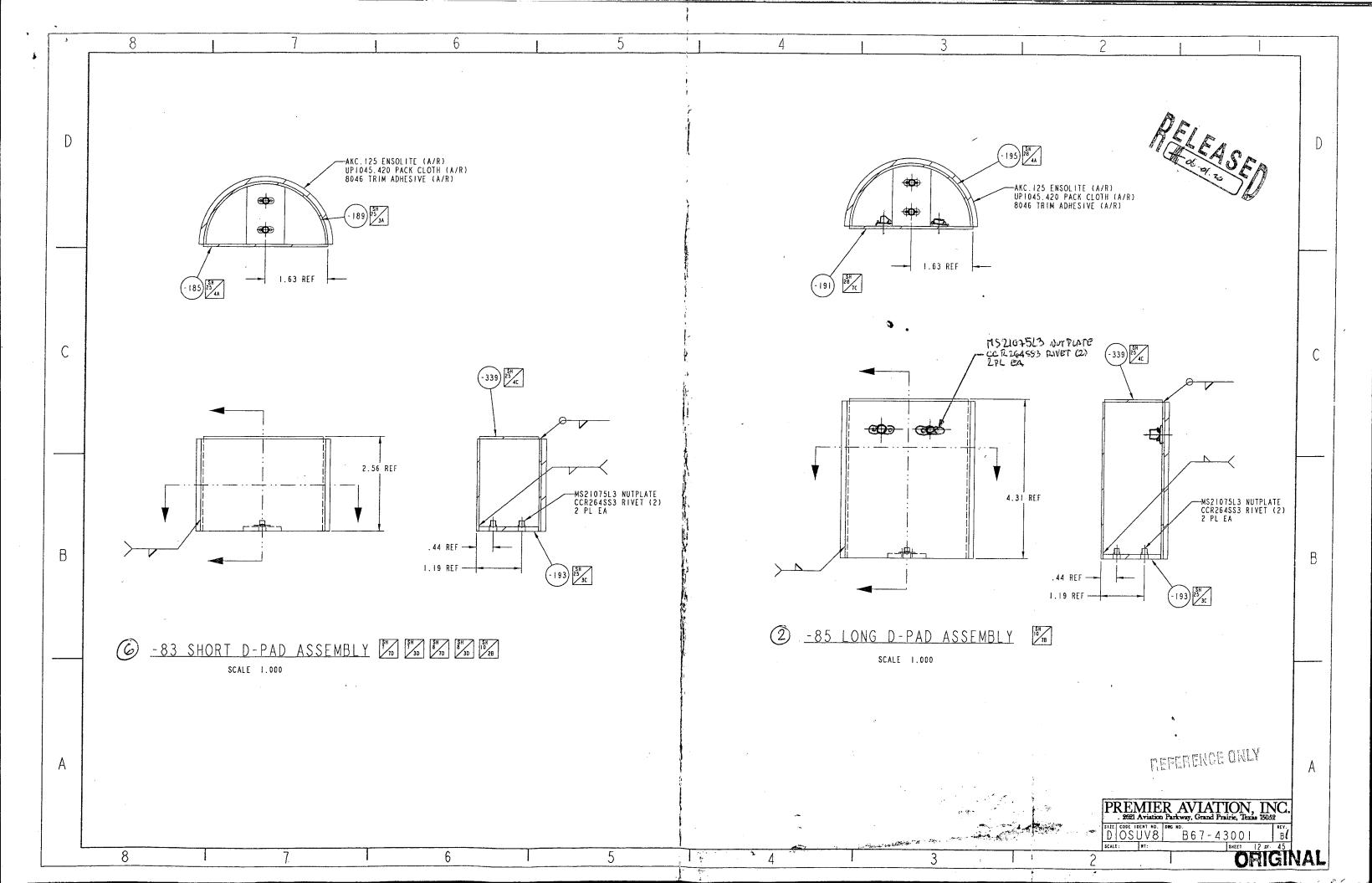
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User:	Dominique Dub	e	Process Sheet
Custor	ner: CC-DAR0	1 Dart Aerospace Ltd.	Drawing Name: PB67-43001-83
1.4. 63.	20252		D 444 1 DD07400400
Job Number:	ber: 36353		Part Number: PB674300183
JOD NUMBER.			
Seq. #:	Machine	Or Operation:	Description :
20.0	QC5		INSPECT WORK TO CURRENT STEP
Cor	mment: INSPE	CT WORK TO CURRE	NT STEP CELOUSE
21.0	PACKAGIN	VG 1	PACKAGING RESOURCE #1
Cor	nment: PACKA	AGING RESOURCE #1	
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	SEND	TO TULMAR FOR FOA	M & FABRIC COVERING
	PO	Sue	_W10'. 36881 P/05440 CX08/01/28
22.0	PACKAGIN	IG 1	PACKAGING RESOURCE #1
Con	nment: PACKA	AGING RESOURCE #1	0///
	RECE!	VE & INSPECT FOR TE	RANSIT DAMAGE
23.0	QC6		DIMENSIONAL CHECK
			N/A
		NSIONAL CHECK	/ 111
24.0	PACKAGIN		PACKAGING RESOURCE #1
Con	ument: PACKA	AGING RESOURCE #1	(/.)
			NIH
05.0		FY & PLACE IN STOCK	
25.0	QC21		FINAL INSPECTIONW/O RELEASE
Con	nment: FINAL	INSPECTION/W/O REL	
Job Completion			mi 2008/1/29 (1)
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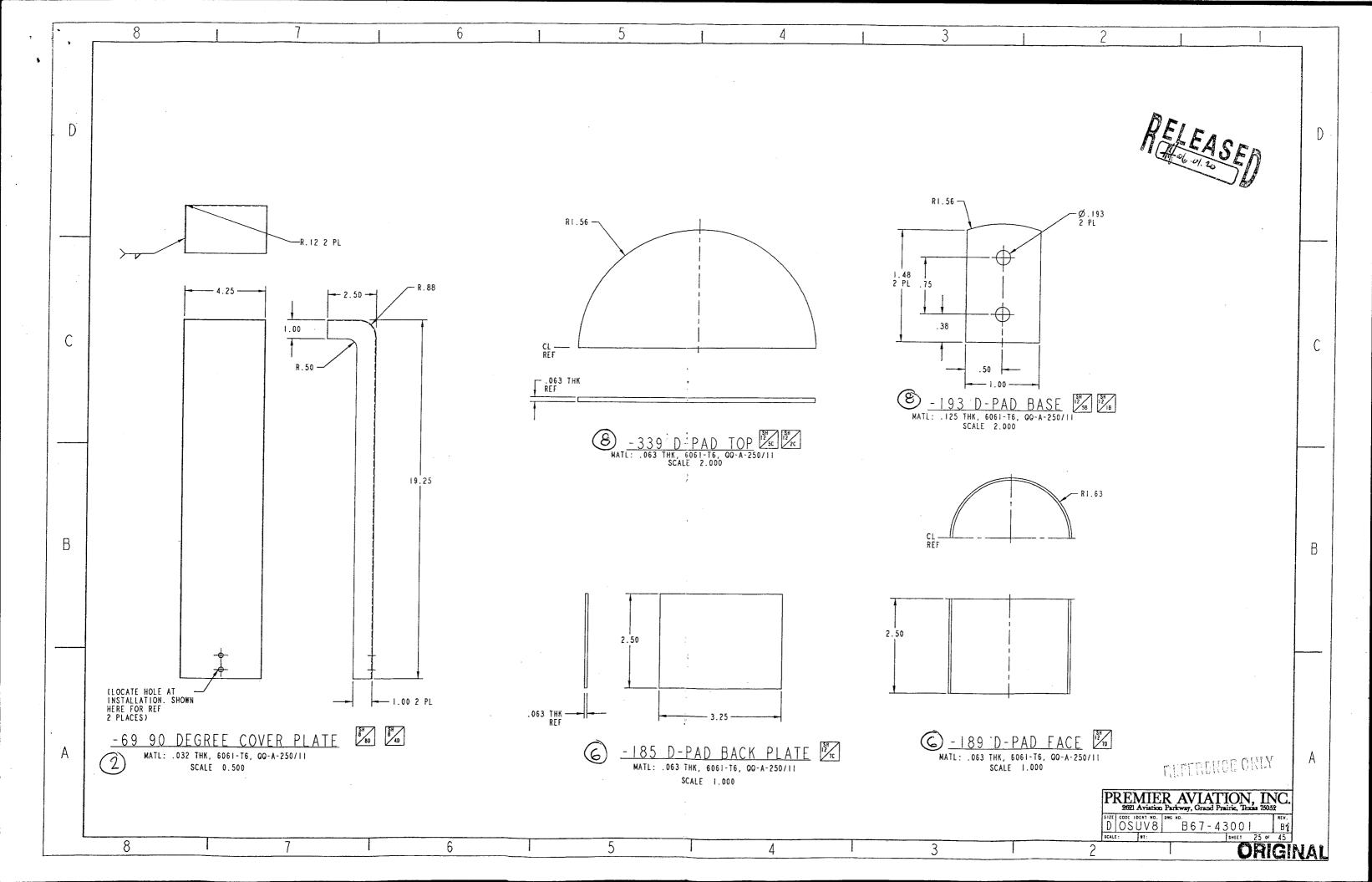
Dart /	Aeros	pace	Ltd
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W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:	_PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
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NCR:								
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annrossal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto
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DART AEROSPACE LTD	Work Order:	36353
Description: PB67-43001-83	Part Number:	PB674300183
Inspection Dwg:PBCH3xd-BRev: N/A		739 Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Date:	07-17-21	Date:	0/12/24	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	rippi o i v
			7 (0/ 5 12/7)	

DART AEROSPACE LTD	Work Order:	3(353
Description: PB674300183	Part Number:	PB 674300183
Inspection Dwg:pB 674301BRev: N/A		\(\frac{1}{3}\) Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	
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Measured by: 😮	Audited by:	d	Prototype Approval:	
Date: 07-12-21	Date:	2/12/24	Date:	

Rev	Date	Change	Revised by	Approved
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DART AEROSPACE LTD	Work Order:	36353
Description: PB 674 306183	Part Number:	PR 674 300183
Inspection Dwg:PB674300(BRev: N/A		185 Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawin g Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
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Rev	Date	Change		
Δ	+		Revised by	Approved
	<u> </u>	New Issue	KJ/JLM	
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